

Work Order ID 163384

Tuesday, June 27, 2017 11:35:33 AM

163384

Page 1

Item ID: D5152-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Post Mount
 Start Date: 7/13/2017 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 7/18/2017 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: DAS 21 9-89 Date: JUL 03 2017 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5152	B								
110	FLOW WATER JET	0.00							
110									
Waterjet	Memo	0.11							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: <u>B</u> Prog Rev: <u>D</u>								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.04							
Quality Control									
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.08							
Quality Control									

DAS
38
9-89

JUL 04 2017

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Item ID: D5152-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Aft Post Mount

Start Date: 7/13/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/18/2017 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
134		0.03							
134						4		DAS 19 9.00	MLL 17-7-17
Small Fab	Memo	0.22							
Small Fab	FORM USING DT10257 AS PER DWG								
136	QC5- Inspect part completeness to step on W/O	0.00				4			
136								DAS 38 9.00	JUL 17 2017
QC	Memo	0.08							
Quality Control									
140	Identify as per dwg & Stock Location: _____	0.00				4			
140								DAS 19-80	JUL 17 2017
Packaging	Memo	0.04							
Packaging	LOCATION: WA001								

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Item ID: D5152-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Post Mount

Start Date: 7/13/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/18/2017 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.40

Quality Control

DAS
21
9-89

JUL 1 R 2017

Picklist Print

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Work Order ID: 163384

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Parent Item: D5152-3

D5152-3

Parent Item Name: Aft Post Mount

Start Date: 7/13/2017

Required Date: 7/18/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 14.09.04 NEW ISSUE DD VERF:JLM IPP
REV:B 15.01.09 AS PER DWG REV.PA4 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S18GA

Purchased

No

110

sf

109.6099

0.097

0.408421

M304S18GA

**

B.F/SC 17/07/14

304/316 .050 Sheet

Location

Loc Qty

Loc Code

MAT020

108.8059

M135779

7.12

M136036

4.65

M136568

16.8959

M136687

2.24

M136790

13.9

M137481

64

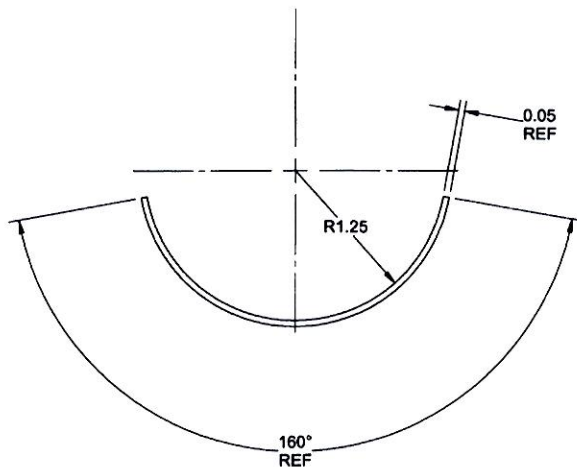
MAT20

0.804

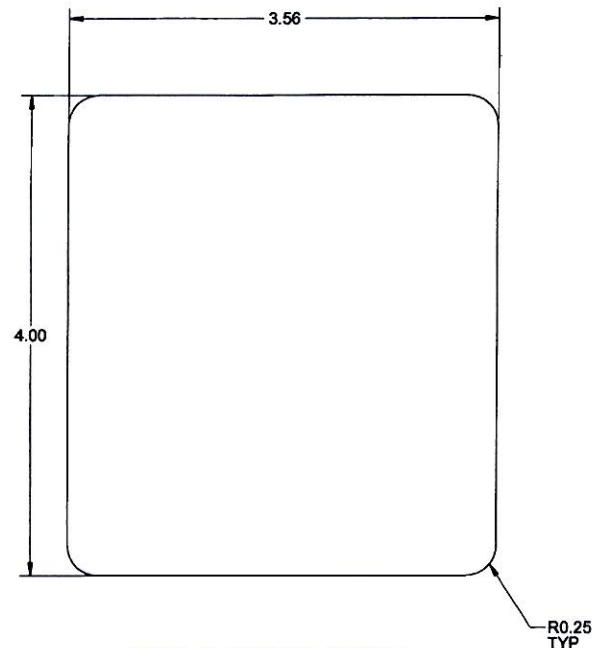
M134580

0.804

0.5



D5152-3 AFT POST MOUNT
(MAKE FROM D5152-3F)



D5152-3F AFT POST MOUNT
(FLAT PATTERN)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 16338445
120703

RELEASED

2015 FEB 09

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240, 0.050" THICK (PER DART SPEC M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

APPROVED

DESIGN	DB	DART AEROSPACE LTD	
DRAWN	EPDMA	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DB	DRAWING NO.	REV. B
MFG. APPR.	DD	D5152	SHEET 4 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	POST MOUNT	NTS
DATE	15.01.09	COPYRIGHT © 2014 BY DART AEROSPACE LTD	
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